

Work Order ID 79076-2

79076

January-19-12 1:40:01 PM

Page 1

Item ID: D3560-041

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Arm Weldment

Start Date: 19/01/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MCT

Date: 12/01/19

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3560

Rev D

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 16.750" long

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Mill as per Folio FA693 Rev: AA & Dwg D3560 Rev: D
2-C'sink 0.196" hole on manual mill as per dwg D3560
3-Deburr per dwg D3560

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID **79076**

79076

Page 2

January-19-12 1:40:01 PM

Item ID: D3560-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Arm Weldment

Start Date: 19/01/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

Re 12.1.30

10 d

140

0.00

140

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Weld assembly as per dwg D3560

STEP:

1- clean material (buff bracket and bottom of arm with blue pad)

2- set up bracket and arm on jig

3- preheat bracket and arm with torch

4- clean before welding with brush

5- set up machine to 135 amps

6- weld across bottom and top ends

7- reheat with torch (65 deg C)

8- on one side weld from bottom to top half way

9- same for other side (half way)

10- from half way point weld the rest of the first side (ease off pedal near end)

11- same for remaining side (ease off pedal near end)

12.02.23 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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N900040100

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4

Cust Item ID:

Required Date: 02/02/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

Quality Control

12 02 23 (9)

160

QC9- Inspect visual per QSI004- Fusion Welds

0.00

160

QC

Memo

0.00

Quality Control

9 12/02/23

170

Chemical Conversion Coat per QSI005 4.1

0.00

170

HandFinish

Memo

0.00

Hand Finishing

9 12/02/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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 Revision ID: Stop ***NS2***
 Item Name: Arm Weldment
 Start Date: 19/01/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 02/02/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC3- Inspect Part Finish	0.00							
180									
QC	Memo	0.00							
Quality Control									
190	Small Fab	0.00							
190									
Small Fab	Memo	0.00							
Small Fab	I-Press bushing in D3560 arm per dwg D3562								
200	QC5- Inspect part completeness to step on W/O	0.00							
200									
QC	Memo	0.00							
Quality Control									

EP 12/02/24 (9)

EP 12/02/24 (9)

MA 12.02.24 (9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 5

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NS1

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210

Identify as per dwg & Stock Location: *U1A*

0.00

210

Packaging

Memo

0.00

Packaging

*** STOCK IN STEP CELL***

12.02.24 9 0

220

QC21- Final Inspection - Work Order Release

0.00

220

QC

Memo

0.00

Quality Control

12/2/24

mf 12-02-24

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

January-19-12 1:40:04 PM

Page 1

Work Order ID: 79076

79076

Parent Item: D3560-041

D3560-041

Parent Item Name: Arm Weldment

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07.05.24 EC
IPP rev B ECN 987 07.10.09 EC verified by: DD
IPP Rev:C ECN1048 07-12-18 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2808		Manufactured	No			100	Each	22.0000	1	4			
-------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D2808

Bushing

Location	Loc Qty	Loc Code
GA	22	
32896	2	
71879	8	
76188	12	

M6061T6B0.500X05.00 0		Purchased	No			140	f	59.7480	1.395	5.873684			
--------------------------	--	-----------	----	--	--	-----	---	---------	-------	----------	--	--	--

M6061T6B0 500X05 000

6061-T6 Bar .500 x 5.00

Location	Loc Qty	Loc Code
MAT001	35.748	
112154	6.935	
117933	4.813	
119324	24	
MAT004	24	
120243	24	

M120421 x 14.69 and 12/01/26

**

**

12/02/24
B78950

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

January-19-12 1:40:04 PM

Page 2

Work Order ID: 79076

Parent Item: D3560-041

Parent Item Name: Arm Weldment

79076

D3560-041

Start Date: 19/01/2012

Required Date: 02/02/2012

Start Qty: 4.00

Required Qty: 4.00

D3592-1

Manufactured No

190

Each

15.0000

1

4

D3592-1

Plate

**

12.223

Location

Loc Qty

Loc Code

WA

6

78934

6

WA002

9

47015

2

48517

7

9

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

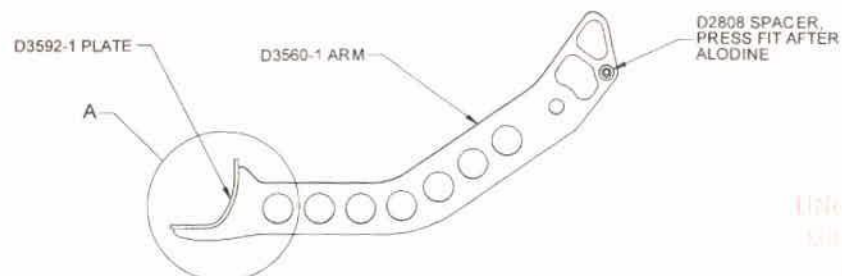
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

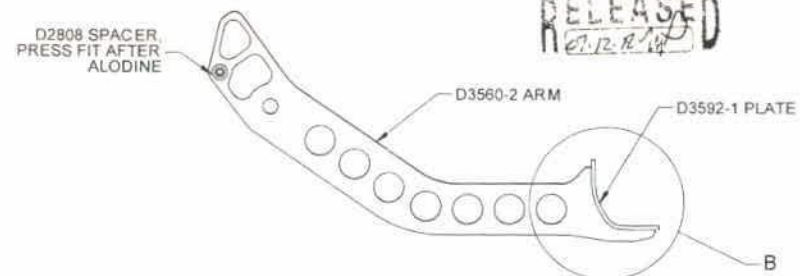
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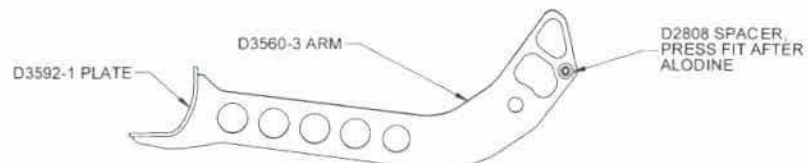
RELEASED
07.12.16



D3560-041 ARM WELDMENT



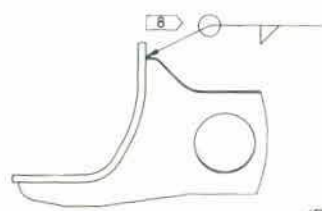
D3560-042 ARM WELDMENT



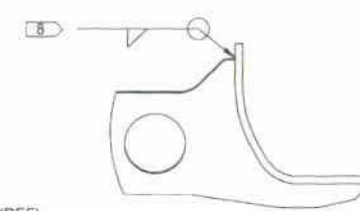
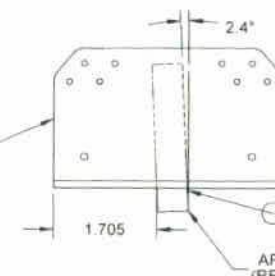
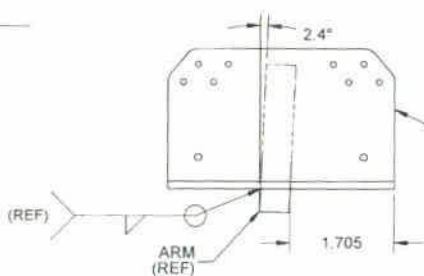
D3560-043 ARM WELDMENT



D3560-044 ARM WELDMENT



**DETAIL A
SCALE 1:2**



**DETAIL B
SCALE 1:2**

PARTS LIST

QTY -041	QTY -042	QTY -043	QTY -044	P/N	DESCRIPTION
X				D3560-041	ARM WELDMENT
	X			D3560-042	ARM WELDMENT
		X		D3560-043	ARM WELDMENT
			X	D3560-044	ARM WELDMENT
1	1	1	1	D2808	SPACER
1				D3560-1	ARM
	1			D3560-2	ARM
		1		D3560-3	ARM
			1	D3560-4	ARM
1	1	1	1	D3592-1	PLATE

DESIGN	ADD D2808 PRESS FIT NOTE: REDRAWN IN SOLIDWORKS	DC	07.11.16
DRAWN	REMOVE POWDER COAT	CP	07.06.19
CHECKED	REDESIGN AS WELDMENT, ADD POCKETS	CP	07.01.15
MFG. APPR.	NEW ISSUE	CP	06.09.25
APPROVED		BY	DATE
DE APPR.			
DATE	07.11.16		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3560	REV. D
TITLE ARM WELDMENT	SHEET 1 OF 5
SCALE 1:4	

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- NOTES**
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX.
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.23 lbs (TYP)
 - 8) WELDING: PER DART QSI 004

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

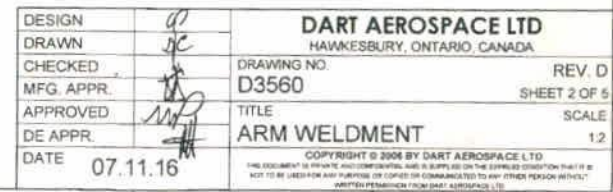
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

7.65 —————
 PROFILE TO MATCH
 D3592-1 PLATE,
 MACHINE AT 2.4°,
 SEE VIEW C-C



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

D3560-2 ARM

NOTES:

- MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC M6061T6B0.500)
- FINISH: NONE
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- IDENTIFICATION: N/A
- WEIGHT: 1.05 lbs

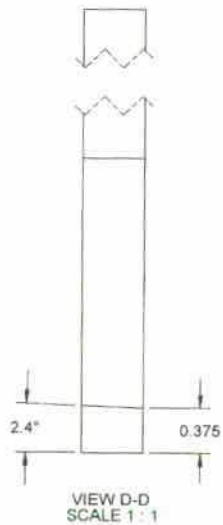
VIEW D-D SCALE 1 : 1

DESIGN	JC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JC	DRAWING NO.	REV. D
CHECKED	JC	D3560	SHEET 3 OF 5
MFG APPR.	JC	TITLE	SCALE
APPROVED	JC	ARM WELDMENT	1:2
DE APPR.	JC	COPYRIGHT © 2008 BY DART AEROSPACE LTD. <small>THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. IT IS THE PROPERTY OF DART AEROSPACE LTD. AND IS LOANED TO YOU FOR YOUR USE ONLY. IT IS NOT TO BE REPRODUCED OR COPIED IN ANY FORM WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DATE	07.11.16		

D3560-2 ARM

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF: DART SPEC M6061T6B0.500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



DESIGN	9	DART AEROSPACE LTD	
DRAWN	JC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JB	DRAWING NO	REV. D
MFG. APPR.	JB	D3560	SHEET 3 OF 5
APPROVED	AMP	TITLE	SCALE
DE APPR.	JB	ARM WELDMENT	1:2
DATE	07.11.16	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS LOANED TO YOU BY THE SUPPLIER FOR THE PURPOSES FOR WHICH IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
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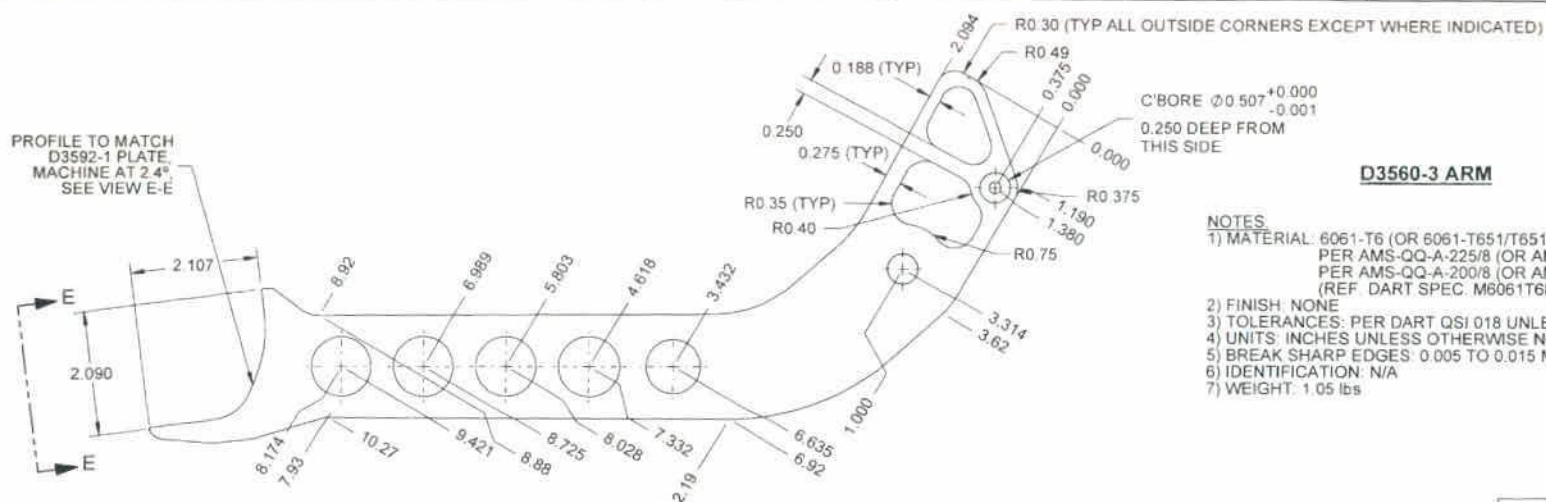
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79076

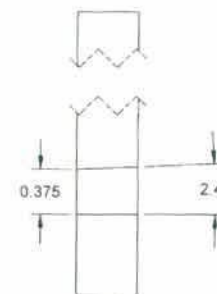
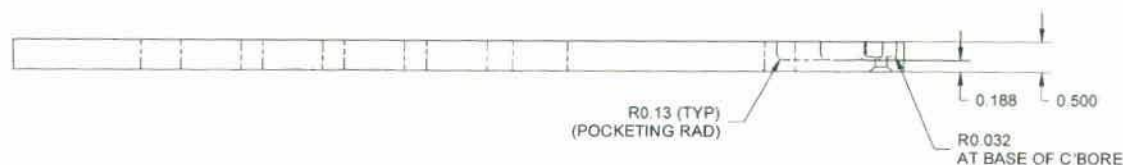
PROFILE TO MATCH
D3592-1 PLATE.
MACHINE AT 2.4°
SEE VIEW E-E



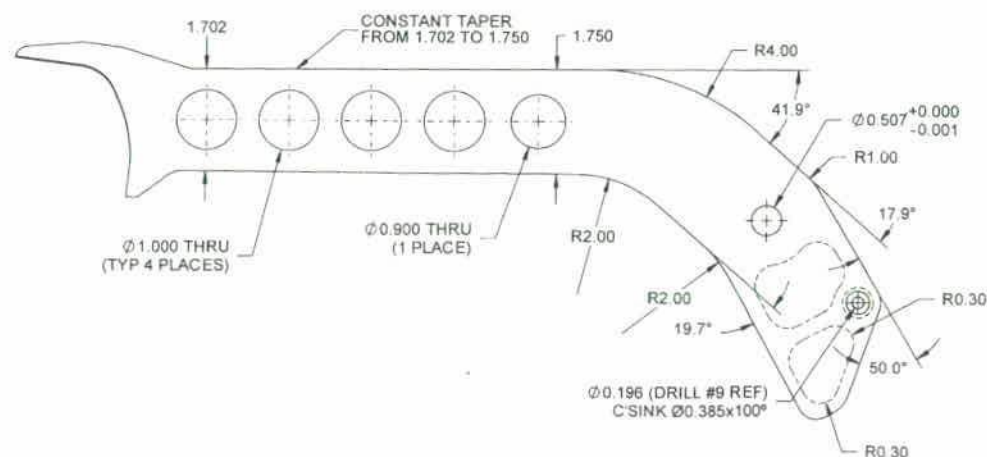
D3560-3 ARM

NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF: DART SPEC. M6061T6B0 500)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.05 lbs



VIEW E-E
SCALE 1:1



DESIGN	4C	DART AEROSPACE LTD	
DRAWN	4C	HAWKESBURY, ONTARIO, CANADA	
CHECKED	4C	DRAWING NO.	REV D
MFG APPR	4C	D3560	SHEET 4 OF 5
APPROVED	4C	TITLE	SCALE
DE APPR	4C	ARM WELDMENT	1:2
DATE	07.11.16	COPYRIGHT © 2004 BY DART AEROSPACE LTD	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4

R0.30 (TYP ALL OUTSIDE CORNERS EXCEPT WHERE INDICATED)

0.188 (TYP)

0.250

0.275 (TYP)

R0.49

0.375

0.000

0.000

R0.375

1.190

1.380

R0.75

R0.35 (TYP)

R0.40

3.432

4.618

5.803

6.989

8.92

2.107

2.090

6.635

6.92

7.332

8.028

8.725

8.88

9.421

10.27

7.99

8.174

3.314

3.62

1.000

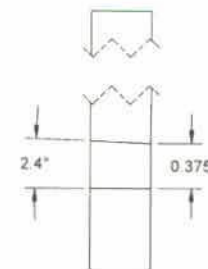
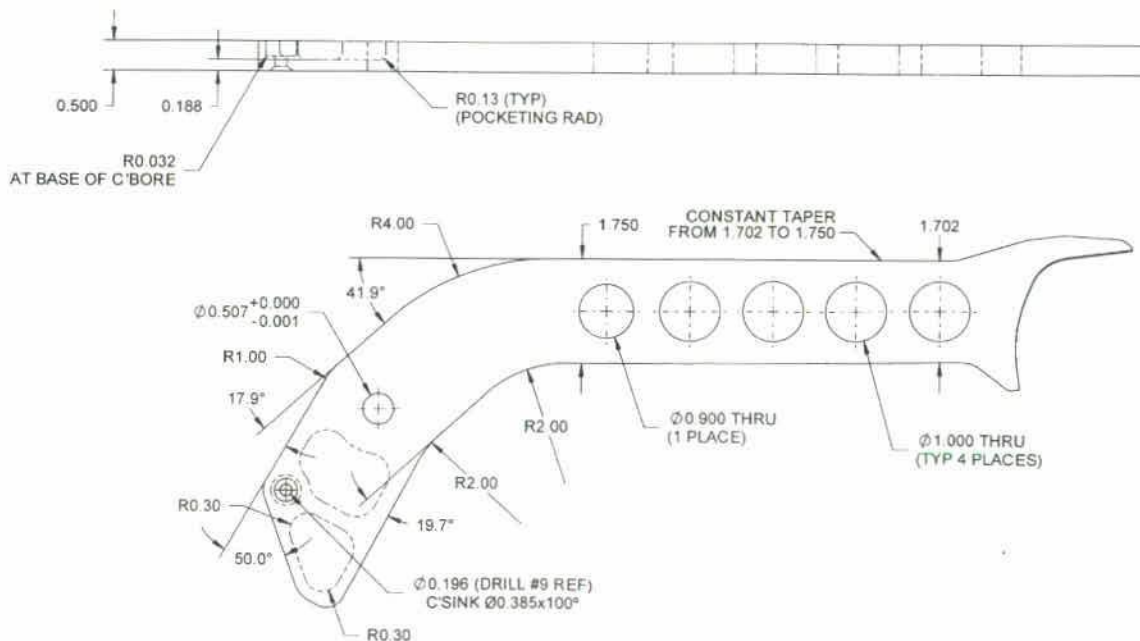
C-BORE $\varnothing 0.507 +0.000 -0.001$
0.250 DEEP FROM THIS SIDE

PROFILE D3592-1 F
MACHINE
SEE VIEW

F

F

NOTES:
1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR, 0.500 THICK
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061TB60.500)
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.015 MAX
6) IDENTIFICATION: N/A
7) WEIGHT: 1.05 lbs



VIEW F-F
SCALE 1/4"

07.12.18 P

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV D
MFG. APPR.		D3560	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		ARM WELDMENT	1:2
DATE	07.11.16	COPY RIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 79076
Description: ARM weldment		Part Number: D3560-1
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 1.000	+0.010 / -0.001	Ø 1.003	✓		SLO2 Mic.	
Ø 0.507	+0.004 / -0.001	Ø 0.5068	✓		"	
Ø .507 x .250 deep	+0.000 / -0.001	Ø .5065 x .252	✓		"	
Ø .188 pocket depth	+/- .010	0.187	✓		SLO8 Vern	
Ø .188	+/- .010	0.190	✓		"	
.250	+/- .010	0.250	✓		"	
.275	+/- .010	0.278	✓		"	
2.000	+/- .010	2.003	✓		"	
1.000	+/- .010	1.005	✓		"	
1.700	+/- .010	1.704	✓		"	
.850	+/- .010	0.851	✓		"	
Ø .196	+0.005 / -0.001	Ø .196	✓		"	
1.375	+/- .010	1.371	✓		"	
2.463	+/- .010	2.466	✓		Height gauge	
.210	+/- .010	0.210	✓		"	
Ø 0.385 x 100°	+/- .010 x .5°	Ø 0.385	✓		SLO8	

Measured by: <i>SP/MA</i>	Audited by: <i>RA</i>	Preliminary Approval:
Date: 12/01/29	Date: 12-1-30	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15